

Work Order ID 91674-1

October-15-12 10:01:18 AM

split

91674

Page 1

Item ID: D205-708-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Adjustable Engine Mount

Start Date: 10/15/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/29/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date: 12/10/15 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B80701

Rev C

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

110

0.00

110

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O:

18123

for:

6	D3284-001	(B80702-1)	Sleeve
2	D3284-003	(B80703-1)	Stud
4	D3284-005	(B80704-1)	Stud
6	D3284-007	(B80705-1)	Stud
6	NAS509-12	Nut	
6	NAS509L12	NutStud	

To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northern Aero
Certificate of Conformity is required

SL 12/12/18

2 J. J. Formis 12-12-18
(2)

CL 12/10/12 (4)

→
Pto

NCR Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: <u>91674-1</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D205-708-011</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 91674

91674

Page 2

October-15-12 10:01:18 AM

Item ID: D205-708-011

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Setup Start *NS1*

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Stop *NS2*

Item Name: Adjustable Engine Mount

Start Date: 10/15/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/29/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Receive & Inspect For Transit Damage Ensure Certificate of Conformity is attached

10/12/12/17 (2)

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Quality Control

Memo

0.00

Inspect assembly. Visually inspect thread, fit and cad plating

0.00
15
10/12/17

J

135

Pick Kit

0.00

135

Packaging

Packaging

Memo

0.00

2x

SPD-12-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

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91674

Page 3

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

150

Packaging

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-708-011

Location:

PPP Rev:

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

DAS
15
9-89

D-12 K

SHIP

2

2x

DAS
20
9-89

12/12/18

MR
12-12-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

October-15-12 10:01:17 AM

Page 1

Work Order ID: 91674

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 10/15/12

Required Date: 10/29/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3284-001 Sleeve		Manufactured	No			140	Each	6.0000	6	24		9/16/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
					24757	6							
D3284-003 Stud		Manufactured	No			140	Each	5.0000	2	8		9/16/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		5							
					32724	3							
					35656	2							
D3284-005 Stud		Manufactured	No			140	Each	11.0000	4	16		9/16/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		6							
					24757	6							
				ST037		5							
					43645	3							
					79831	2							
D3284-007 Stud		Manufactured	No			140	Each	6.0000	6	24		9/16/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST037		6							
					24757	6							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---

Picklist Print

October-15-12 10:01:17 AM

Page 2

Work Order ID: 91674

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 10/15/12

Required Date: 10/29/12

Start Qty: 4.00

Required Qty: 4.00

D3284-009
Bearing

Manufactured No

140 Each 6.0000

6 24

SP. SP

Location

Loc Qty

Loc Code

ST036

4

24775

0

89216

4

ST037

2

86758

2

2x

SPB 2x

D3284-011
Bearing

Manufactured No

140 Each 5.0000

1 4

SP SP

Location

Loc Qty

Loc Code

ST037

5

60004

5

2x

SPB 2x

MS20613-6C12
RIVET

Purchased No

140 Each 76.0000

2 8

SP SP

Location

Loc Qty

Loc Code

ST322

76

105433

76

4x

SPB 2x

MS20613-6C16
Rivet

Purchased No

140 Each 452.0000

8 32

SP SP

Location

Loc Qty

Loc Code

ST322

452

115358

440

19392

12

16x

SPB 2x

MS20613-6C18
Rivet

Purchased No

140 Each 7.0000

8 16

SP SP

Location

Loc Qty

Loc Code

ST322

7

19513

7

SPB 8x 16x
3x M19513
13 M20212
Pto.

SPB 2x

MS20613-6C19
Rivet

Purchased No

140 Each 0.0000

12 48

SP SP

Location

Loc Qty

Loc Code

M15921 5x.
M16205 2x.
M16255 12x.
M19349 5

SPB 2x

October-15-12 10:01:17 AM

Shop Packet Print

Page 2

SP 12-12-17

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 3

Work Order ID: 91674

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 10/15/12

Required Date: 10/29/12

Start Qty: 4.00

Required Qty: 4.00

NAS509-12

Purchased

No

140

Each

48.0000

6

24

Nut

Shrs 2

Location

Loc Qty

Loc Code

ST279

48

15057

42

24757

6

NAS509L12

Purchased

No

140

Each

44.0000

6

24

Nut

Shrs 2

Location

Loc Qty

Loc Code

ST280

44

102296

29

15062

9

24757

6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY					
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube		General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH
 MIN Ft_u = 90 Ksi
 MIN Ft_y = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

L12/10/15
 W/O: 91674

RELEASED

2010-03-25

W

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. REV. B D3284 SHEET 1 OF 1	
MFG. APPR.			
APPROVED		TITLE SCALE ADJUSTABLE ENGINE MOUNT NTS	
DE APPR.			
DATE	09.07.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

ACS-NAI Ltd.

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-772-9922
Fax : 204-772-7568

Delivery No. : 3350
Delivery Date : 12/14/2012
SO No. : 27672
Your Reference : PO: 18123
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Part Number	Total		Qty		Delivery Date
		Ordered	Unit	Delivered		
B80702-1	SLEEVE 11-4293 (4) 12-4609 (5)	12	EA	12		12/18/2012
B80703-1	7/8" STUD 11-4294 (1) 12-4611 (3)	4	EA	4		12/18/2012
B80704-1	3/4" MALE STUD 11-4295 (2) 12-4614 (6)	8	EA	8		12/18/2012
B80705-1	STUD 12-4615 12-4615	12	EA	12		12/18/2012
NAS509-12	NUT (.7500-16 UNJF-3B) 11-3879	12	EA	12		12/18/2012
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 11-3686	12	EA	12		12/18/2012
ASSEMBLY	ENGINE MOUNT KIT	2	EA	2		12/14/2012
Packages: 0		Gross Weight: 0.00		Net Weight:		

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

0.00

Remarks**Certification Statement**

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date:

14 Dec 12

CERTIFICATE OF CONFORMITY

Form Tracking No. 27672-2

Work Order/Contract/Invoice
PO: 18123

Cage Code: MFR L0555

Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Sleeve	B80702-1	4	11-4293	New
2	Sleeve	B80702-1	8	12-4609	New
3	Stud	B80703-1	1	11-4294	New
4	Stud	B80703-1	3	12-4611	New
5	Stud	B80704-1	2	11-4295	New
6	Stud	B80704-1	6	12-4614	New
7	Stud	B80705-1	12	12-4615	New

Remarks:

THESE ITEMS CONFORM TO DESIGN DATA B80702 (REV. A); B80703 (REV. A); B80704 (REV. A) AND B80705 (REV B), AS APPLICABLE.

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature

Name R. D. WILLIAMSON

Date (dd mmm yyyy)
14-Dec-12

Used, Repaired or Overhauled Parts Certification

The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.

Signature

Name

Date (dd mmm yyyy)

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18123

Purchase Order Date 10/15/12

PO Print Date 10/16/12

Page Number 1 of 2

Order From :

VU-NOR003

NORTHERN AERO INDUSTRIES LTD.
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

204-772-9922

204772-7568

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B80702-1	Sleeve	10/26/12 Yes	24.00 Each <i>See 12</i>	FedEx PI collect	\$117.0000	\$2,808.00
		Special Inst:	D3284-001 Sleeve ACS P/N B80702-1 per ACS DWG B80702 Rev:A				
2	B80703-1	Stud	10/26/12 Yes	8.00 Each <i>See 4</i>	FedEx PI collect	\$98.0000	\$784.00
		Special Inst:	D3284-003 Stud ACS p/n B80703-1 per ACS Dwg:B80703 Rev: A				
3	B80704-1	stud	10/26/12 Yes	16.00 Each <i>See 8</i>	FedEx PI collect	\$87.0000	\$1,392.00
		Special Inst:	D3284-005 Stud ACS p/n B80704-1 per ACS DWG: B80704 Rev: A				

PO Instructions:

PLEASE ADVISE DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr:

2

Change Date: 10/16/12



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18123

Purchase Order Date 10/15/12

PO Print Date 10/16/12

Page Number 2 of 2

Order From :

VU-NOR003

NORTHERN AERO INDUSTRIES LTD.
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

204-772-9922

204772-7568

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

4	B80705-1	stud	10/26/12 Yes	24.00 Each	FedEx PI collect <i>Net 12</i>	\$99.5520	\$2,389.25
		Special Inst:	D3284-007 Stud ACS p/n B80705-1 per ACS Dwg: B80705 rev.a				
5	NAS509-12	Nut	10/26/12 Yes	24.00 Each	FedEx PI collect <i>Net 12</i>	\$11.5400	\$276.96
6	NAS509L12	Nut	10/26/12 Yes	24.00 Each	FedEx PI collect <i>Net 12</i>	\$22.4298	\$538.32
7	91674	D205-708-011 ADJ ENGINE MOUNT	10/26/12 Yes	4.00	FedEx PI collect <i>Net 12</i>	\$20.0000	\$80.00

Special Inst: TO BE ASSEMBLE AS PER DWG B80701
REV. C

PO Total:

\$8,268.52

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

PO Instructions:

PLEASE ADVISE DELIVERY

Change Nbr:

2

Change Date: 10/16/12

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO

4.0 PARTS LIST

Qty -043	Qty -013	Qty -041	Qty -011	Part Number	Description
			X	D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
		X		D205-708-041	ADJUSTABLE ENGINE MOUNT ASSEMBLY (205/UH-1)
	X			D204-708-013	ADJUSTABLE ENGINE MOUNT KIT (204)
X				D204-708-043	ADJUSTABLE ENGINE MOUNT ASSEMBLY (204)
	6		6	D3284-001	SLEEVE
			2	D3284-003	STUD
	6		4	D3284-005	STUD
	6		6	D3284-007	STUD
	6		6	D3284-009	BEARING
	1		1	D3284-011	BEARING
1				D3284-021	TUBE ASSEMBLY
1				D3284-023	BIPOD ASSEMBLY
1				D3284-025	TRIPOD ASSEMBLY
		1		D3284-031	TUBE ASSEMBLY
		1		D3284-033	BIPOD ASSEMBLY
		1		D3284-035	TRIPOD ASSEMBLY
	2		2	MS20613-6C12	RIVET
	12		8	MS20613-6C16	RIVET
			8	MS20613-6C18	RIVET
	12		8	MS20613-6C19	RIVET
	6		6	NAS509-12	NUT
	6		6	NAS509L12	NUT

5.0 WEIGHT AND BALANCE

The following is the net weight and moment change associated with this installation

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-708-011 Adjustable Engine Mount Kit (205/UH-1)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	188.5 in 4.79 m	1810 lb-in 21.1 kg-m
D205-708-041 Adjustable Engine Mount Assembly (205/UH-1)					
D204-708-013 Adjustable Engine Mount Kit (204)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	184.5 in 4.69 m	1771 lb-in 20.6 kg-m
D204-708-043 Adjustable Engine Mount Assembly (204)					

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Revision: A
Date: 05.07.20

REFERENCE OF A